

Work Order ID 101995

101995

Page 1

May-22-13 10:59:42 AM

Item ID: D4770-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 5/22/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4770

A

0.00

100

100

Cold Saw

Hyd Mech

Memo

Cut blanks as per dwg

0.00

100 13/05/22
D.A.

2 *Ø*

0.00

110

110

HAAS I

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB182 & dwg D4770-5,

FOLIO REV: AA

DWG REV: A

0.00

110 13/05/23
D.A.

2 *Ø*

2-Deburr as required

~~***EXTRA MATERIAL WILL BE CUT AT ASSEMBLY***~~

AA

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May-22-13 10:59:42 AM

Item ID: D4770-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bar
Start Date: 5/22/13 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 5/24/13 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A. / MWP 13/05/23			2	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B-5-27			2	0		DAS 04 2-83
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA001</u> Memo	0.00 0.00				x2		13-05-27	MAL

Work Order ID 101995

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May-22-13 10:59:42 AM

Item ID: D4770-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 5/22/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

13/5/27

Picklist Print

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Page 1

Work Order ID: 101995

Parent Item: D4770-5

Parent Item Name: Bar

Start Date: 5/22/13

Required Date: 5/24/13

Start Qty: 2.00

Required Qty: 2.00

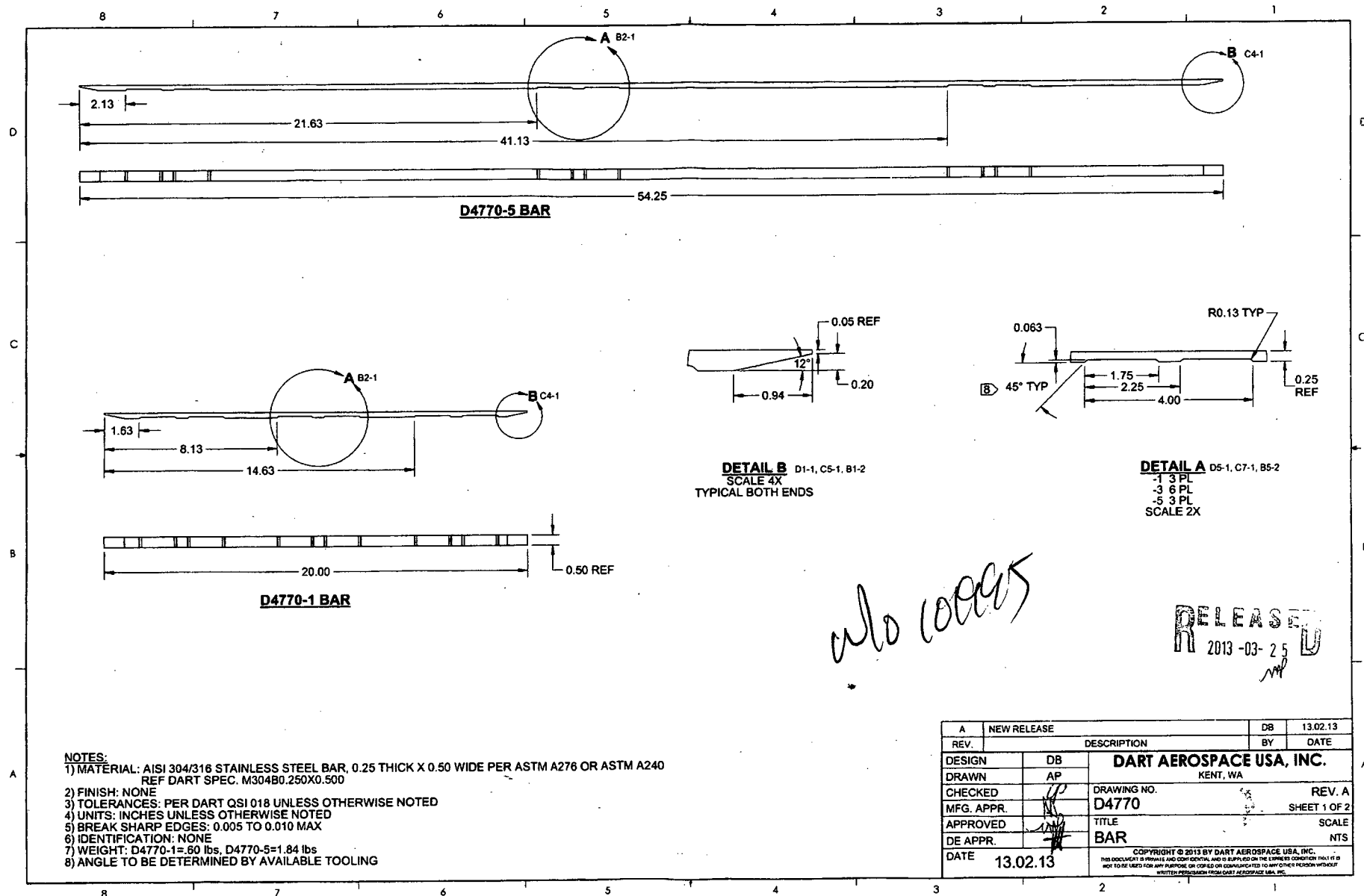
Comments: IPP REV:A 13.04.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	482.3470	4.52	9.5157895			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT049	482.347	
123902	31.492	
124518	222.855	
125367	228	

WIP 13/05/23

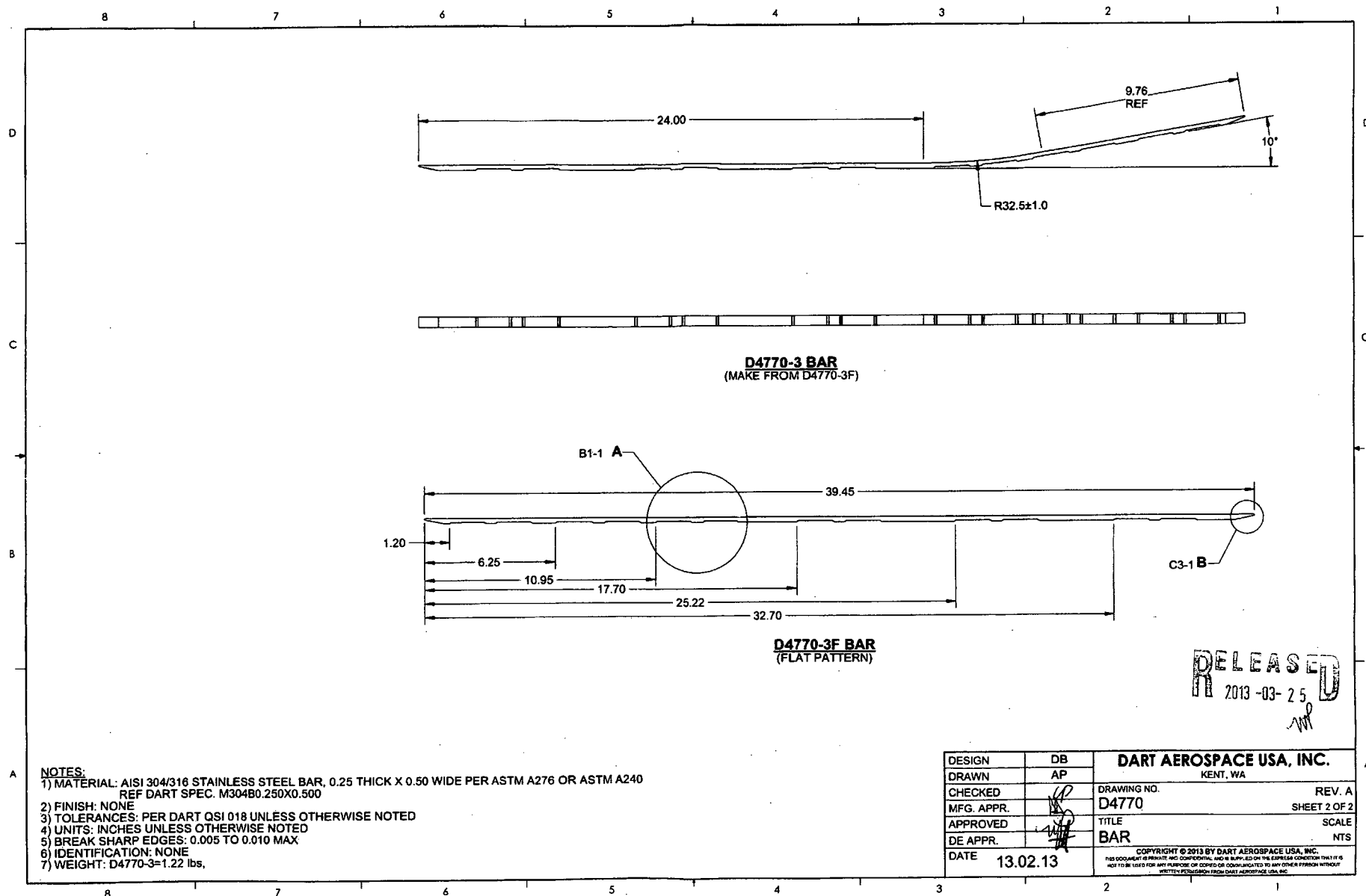
10,041'



also 100005

RELEASED
2013-03-25

A NEW RELEASE		DB	13.02.13
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4770	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4770-3=1.22 lbs,

DESIGN		DB		DART AEROSPACE USA, INC.	
DRAWN		AP		KENT, WA	
CHECKED		[Signature]		DRAWING NO.	
MFG. APPR.		[Signature]		D4770	
APPROVED		[Signature]		TITLE	
DE APPR.		[Signature]		BAR	
DATE		13.02.13		REV. A	
				SHEET 2 OF 2	
				SCALE	
				NTS	

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